COR™ TOOL S7 MC

DESCRIPTION
COR™ TOOL S7 MC is a metal-cored, shock resistant AISI S-7 alloy, and is available in gas shielded, and TIG wires.

APPLICATIONS
S7 MC is typically used for the repair and reclamation of AISI S-series shock resistant tool steels. It is also well suited for coldworking applications, and the composite fabrication of blanking, trimmer, header and brake dies.

PROCEDURE
A minimum preheat/interpass temperature of 600-800°F is recommended for AISI S-7. Peening is recommended. Allow the welded part to cool as slow as possible. Temper at 600°F for one hour per inch thickness. Refer to the AISI S-7 procedure for a full heat treatment.

WELDING PARAMETERS

<table>
<thead>
<tr>
<th>Size</th>
<th>Volts</th>
<th>Amps</th>
<th>Shielding Gas/Flux</th>
</tr>
</thead>
<tbody>
<tr>
<td>MC-G .045”</td>
<td>20-22</td>
<td>160-180</td>
<td>75%Ar-25%CO₂</td>
</tr>
<tr>
<td>MC-G 1/16”</td>
<td>21-23</td>
<td>160-200</td>
<td>75%Ar-25%CO₂</td>
</tr>
</tbody>
</table>

MECHANICAL PROPERTIES

Hardness: 54-58 Rc as welded

CLASSIFICATION

AISI S-7